

# Work Order ID 77368

Tuesday, December 06, 2011 11:01:16 AM

**\*77368\***

Page 1

Item ID: D4532-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: CoPilot Panel

Stop

**\*NS2\***

Start Date: 12/6/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/8/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: MK

Date: 11-12-06

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4532

A

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-12-6

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B11-12-6

Tuesday, December 06, 2011 11:01:16 AM

**\*77368\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/6/2011      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 12/8/2011      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

**Insp.  
Stamp**

0.00

**\*120\***

0,00

QC

## Memo

## Quality Control

0.00

\*130\*

NC BRAKE

HandFinish

## Memo

## Hand Finishing

0.00

**\*140\***

QC

## Memo

## Quality Control

**Work Order ID 77368****\*77368\***

Page 3

Tuesday, December 06, 2011 11:01:16 AM

Item ID: D4532-1      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: CoPilot Panel  
Start Date: 12/6/2011      Start Qty: 1.00      **\*1\***      Cust Item ID:  
Required Date: 12/8/2011      Req'd Qty: 1.00      **\*1\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

11/12/17 *[Signature]*

11/12/18 *[Signature]*

11-12-17

# Picklist Print

Tuesday, December 06, 2011 11:01:16 AM

Page 1

Work Order ID: 77368

Parent Item: D4532-1

Parent Item Name: CoPilot Panel

Start Date: 12/6/2011

Required Date: 12/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.11.30 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	79.8400	2.35	2.4736842			

Location

Loc Qty

Loc Code

MAT021

79.84

113608

65.35

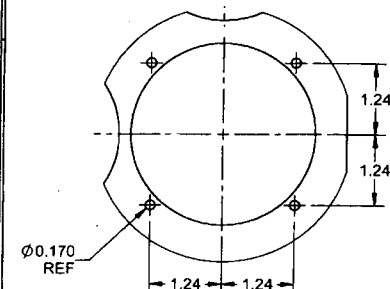
118217

14.49

113608

113608

①

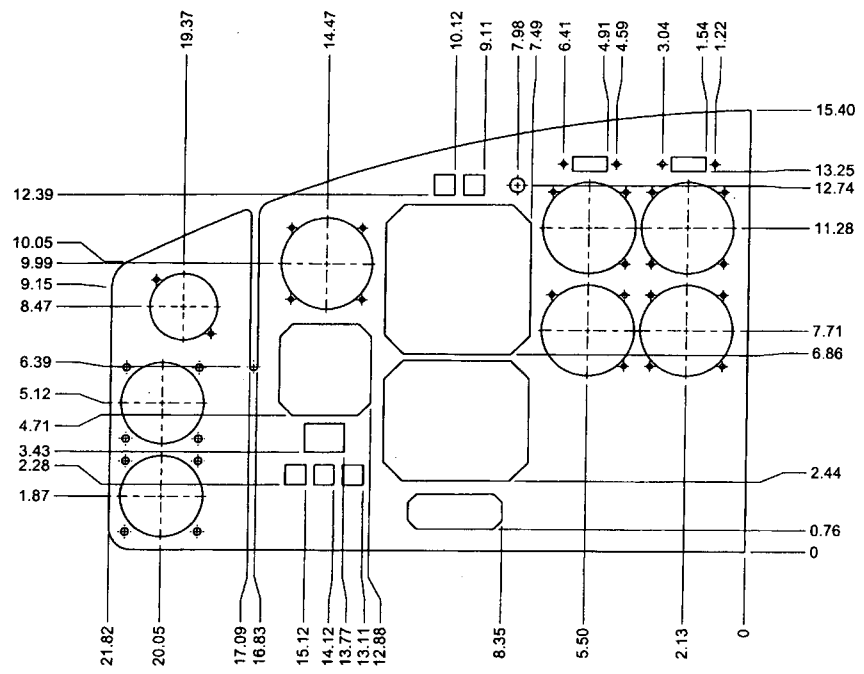


**DETAIL C**  
**SCALE 2X** B3-1

RELEASE  
2011-12-01

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
7) WEIGHT: 2.09 lbs

A	NEW ISSUE			11.11.29
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4532</b>  TITLE <b>INSTRUMENT PANEL</b>		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED	N/A			
DE APPR.	N/A			
DATE	11-11-29	COPYRIGHT © 2011 BY DART AEROSPACE LTD. ALL RIGHTS RESERVED. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE CUSTOMER ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		



**D4532-1 CO-PILOT PANEL**  
AUXILIARY VIEW

# 77368

**RELEASED**  
2011-12-01  
MP

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4532	SHEET 2 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	<b>INSTRUMENT PANEL</b>	NTS
DATE	11-11-29	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD	Work Order: 77368
Description: Co Pilot PANEL	Part Number: D4532-1
Inspection Dwg: D4532-1 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .170	+ .055 - .001	.172	2		V B02	
Ø .250	+ .055 - .001	.252	2		V	
Ø .500	+ .056 - .001	.502	2		V	
Ø 2.300	+ .012 - .001	2.299	2		V	
Ø 2.830	+ .012 - .001	2.830	2		V	
Ø 3.170	+ .012 - .001	3.169	2		V	
.70	± .030	.701	2		V	
.150	± .030	.501	2		V	
1.18	± .030	1.179	2		V	
4.95	± .030	4.942	2		V	
5.20	± .030	5.191	2		V	
4.20	± .030	4.196	2		V	
3.22	± .030	3.217	2		V	
1.22	± .030	1.216	2		V	
3.18	± .030	3.173	2		V	
1.40	± .030	1.398	2		V	
1.00	± .030	.994	2		V	
.76	± .030	.767	2		V	
2.44	± .030	2.419	2		V	
6.86	± .030	6.881	2		V	
7.71	± .030	7.71	2		V	
11.28	± .030	11.28	2		T B01	
12.74	± .030	12.74	1		T	

Measured by: PB	Audited by: J	Prototype Approval:
Date: 11-12-6	Date: 11/12/67	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order: 77368
Description: Co PILOT PANEL	Part Number: D4535-1
Inspection Dwg: D4535-1 Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.25	±.030	13.25	2		T B01	
15.40	±.030	15.40	2		T	
1.87	±.030	1.87	2		V B02	
2.28	±.030	2.285	2		V	
3.43	±.030	3.434	2		L	
4.71	±.030	4.722	2		V	
5.12	±.030	5.12	2		V	
6.39	±.030	6.394	2		V	
8.47	±.030	8.47	2		T	
9.15	±.030	9.15	2		T	
9.99	±.030	9.99	2		T	
10.05	±.030	10.05	2		T	
12.39	±.030	12.39	2		T	
2.13	±.030	2.13	2		V	
5.50	±.030	5.50	2		V	
8.35	±.030	8.35	2		T	
12.88	±.030	12.88	2		T	
13.11	±.030	13.11	2		T	
13.77	±.030	13.77	2		T	
14.12	±.030	14.12	2		T	
15.12	±.030	15.12	2		T	
16.83	±.030	16.83	2		T	
17.09	±.030	17.09	2		T	

Measured by: RB	Audited by: J	Prototype Approval:
Date: 11-12-6	Date: 11/17/9	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



Work Order: 77368

Part Number: D4530-1

Page 1 of 1



## Prototype

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	